

Work Order ID 140677

January 13, 2016 1:16:57 PM

140677

Stock shortage

Page 1

Item ID: D4095-051

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearpad Fwd

Start Date: 1/13/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 1/27/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: *SK*

Date: 20160113

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4095

C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.01

FLOW CNC Waterjet

1-Cut as per Dwg (D4095-11)

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

(12)

da 16/01/26

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(12)

da 16/01/26

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(12)

DAS
38
9-89

JAN 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Work Order ID 140677

January 13, 2016 1:16:57 PM

140677

Page 2

Item ID: D4095-051 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad Fwd
Start Date: 1/13/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 1/27/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00			DAS 30 9-89	12			JAN 27 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(12)			DAS 38 9-89 JAN 27 2016
150 *150* HandFinish Hand Finishing	 Memo COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: <u>133808</u>	0.00 0.01				12			DAS 41 9-89 16-1-27

Work Order ID 140677***140677***

January 13, 2016 1:16:57 PM

Page 3

Item ID: D4095-051

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearpad Fwd

Stop

NS2

Start Date: 1/13/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 1/27/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

DAS

38

9-89

JAN 28 2016

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

Packaging

LOCATION : FP001

DAS

6

9-89

JAN 29 2016

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.02

Quality Control

JAN 29 2016

JAN 29 2016

Picklist Print

January 13, 2016 1:17:01 PM

Page 1

Work Order ID: 140677

140677

Parent Item: D4095-051

D4095-051

Parent Item Name: Wearpad Fwd

Start Date: 1/13/2016

Required Date: 1/27/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP rev.A 11.11.07 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

sf

162.4500

2.34

M304S16GA

304/316 Sheet .063

DL 16/01/26

Location

Loc Qty

Loc Code

MAT019

162.45

m132797

2.45

m133511

160

3

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD

D4095-041/-043/-045/-047/-049/-051 NOTES:

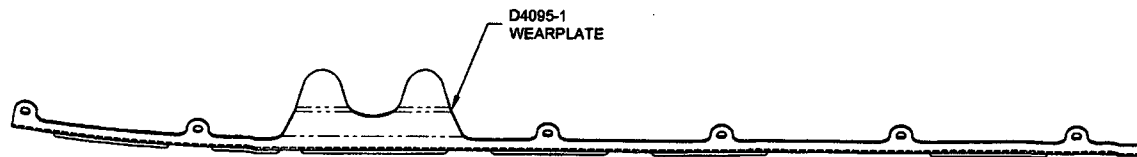
- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BX000X" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT CENTERLINE

20160113 SH 140677

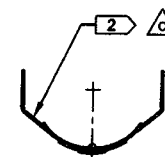
C	8259 WELD ROD WAS 2059B, 0.20 WELD THICKNESS WAS 0.25, MOVE DRAIN HOLE IN -1/3, 0.9 WAS 2.00 (TYPO B4-9), ADJUST TOL. FOR MANUFACTURABILITY, NOTE 2 NOW REF'S QSI 005 4.9, UPDATE MATL SPEC	CP	16.01.06
B	REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCK-GUARD REPLACES D4096-1/-3; ADDED D4095-5/-7 -9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	16.01.06		

DART AEROSPACE USA, INC EUGENE, OR	
DRAWING NO. D4095	REV. C SHEET 1 OF 9
TITLE WEARPLATE	SCALE NTS
COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

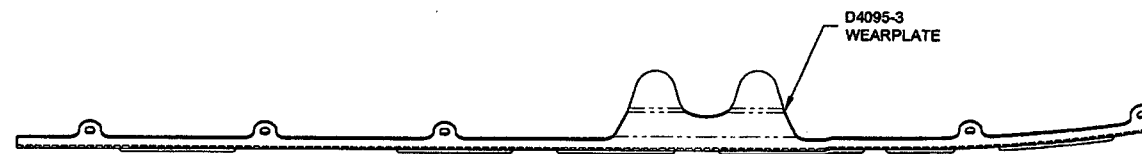
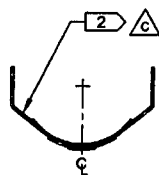
RELEASED
2016-01-11
KIN 16-504



D4095-1
WEARPLATE

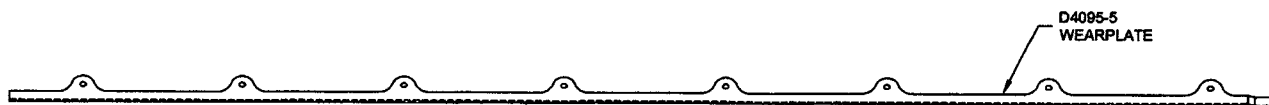


D4095-041 WEARPLATE ASSEMBLY

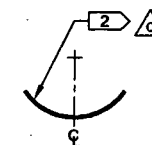


D4095-3
WEARPLATE

D4095-043 WEARPLATE ASSEMBLY



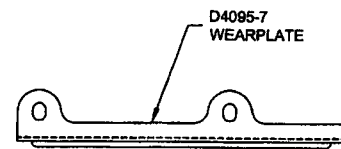
D4095-5
WEARPLATE



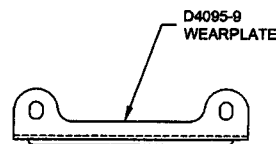
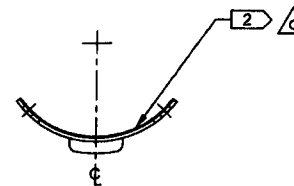
D4095-045 WEARPLATE ASSEMBLY

RELEASED
2016-01-11

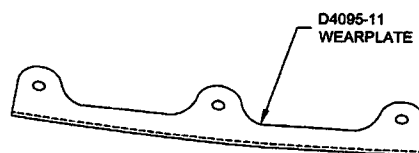
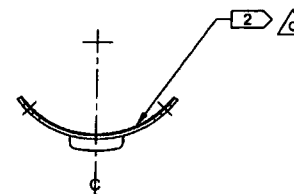
DESIGN		DART AEROSPACE USA, INC	
DRAWN		EUGENE, OR	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4095	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NT
DATE	16.01.06	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			



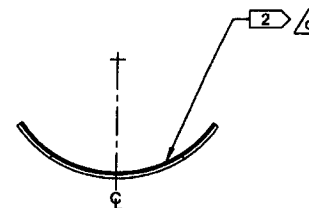
D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY

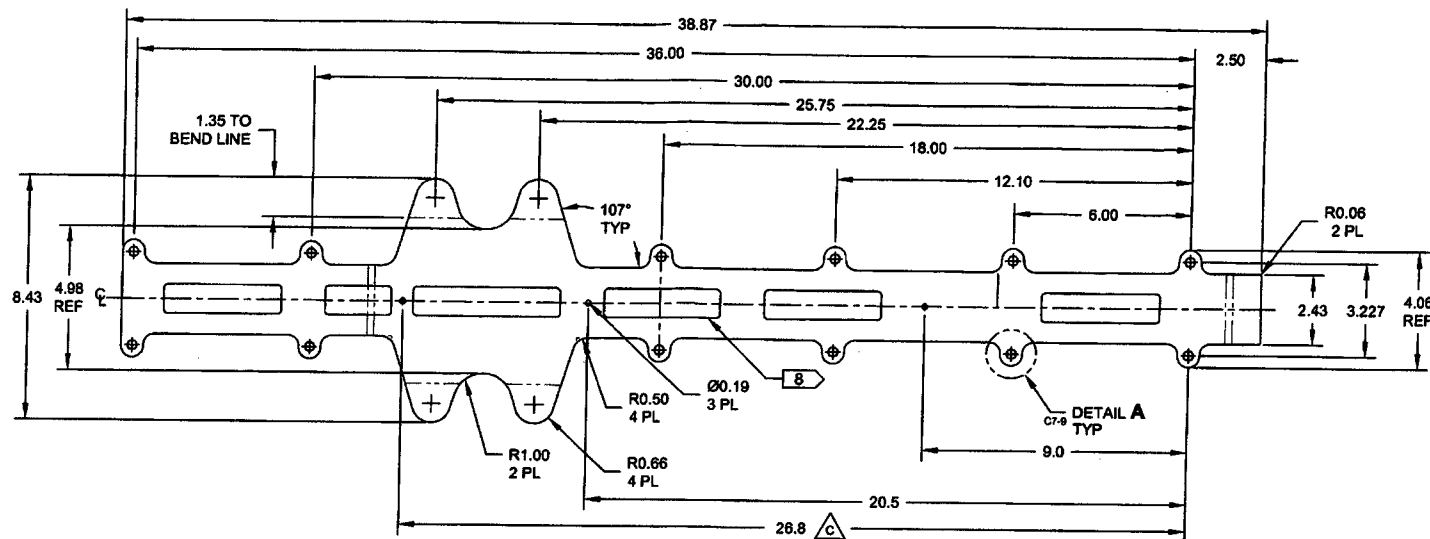


D4095-051 WEARPAD ASSEMBLY

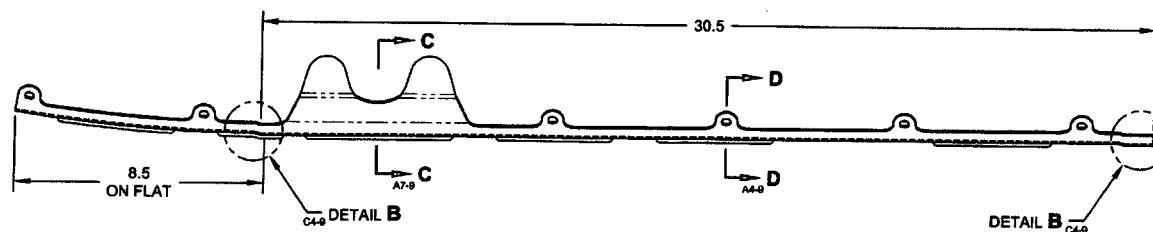


RELEASED
2016-01-11

DESIGN		DART AEROSPACE USA, INC	
DRAWN		EUGENE, OR	
CHECKED		DRAWING NO. D4095	REV. C
MFG. APPR.		SHEET 3 OF 9	
APPROVED		TITLE WEARPLATE	SCALE NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	
DATE	16.01.06	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D4095-1F FLAT PATTERN 1



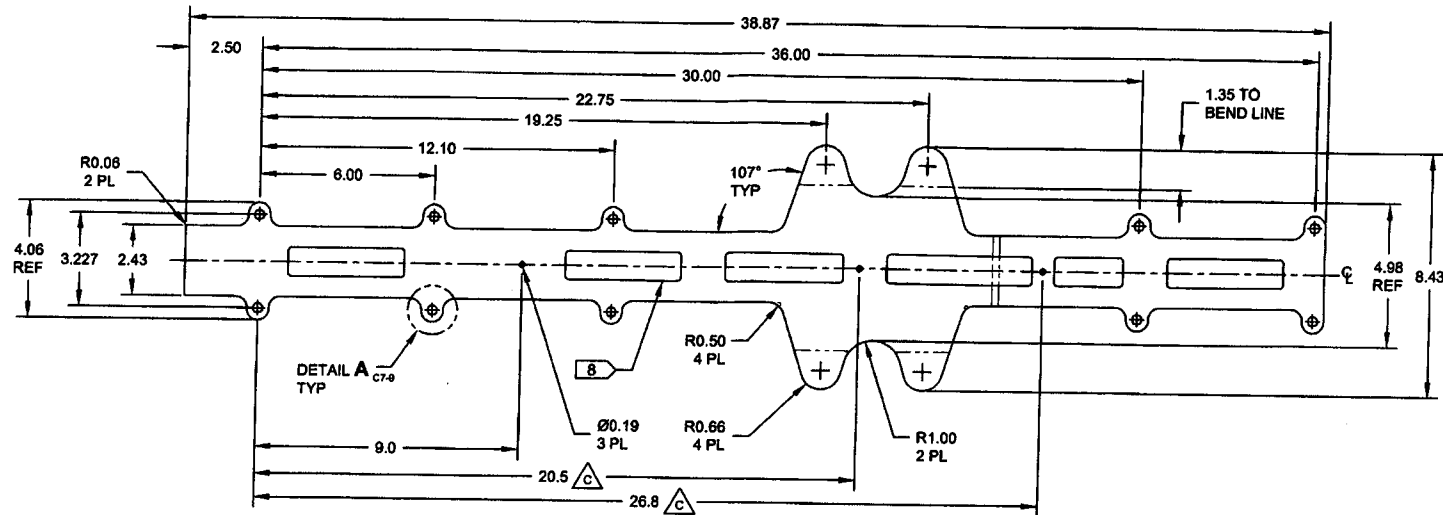
D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1 NOTES:

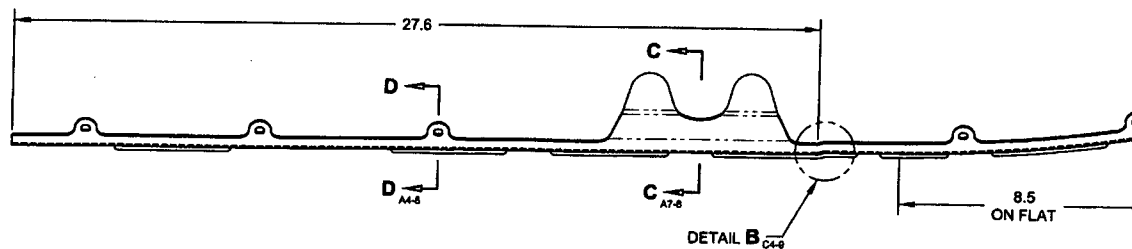
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240
OR ASME SA240 REF DART MATERIAL SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5
- 9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

RELEASED
2016-01-11

DESIGN		DART AEROSPACE USA, INC	
DRAWN		EUGENE, OR	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D4095	SHEET 4 OF 9
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	16.01.06	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D4095-3F FLAT PATTERN 1



D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

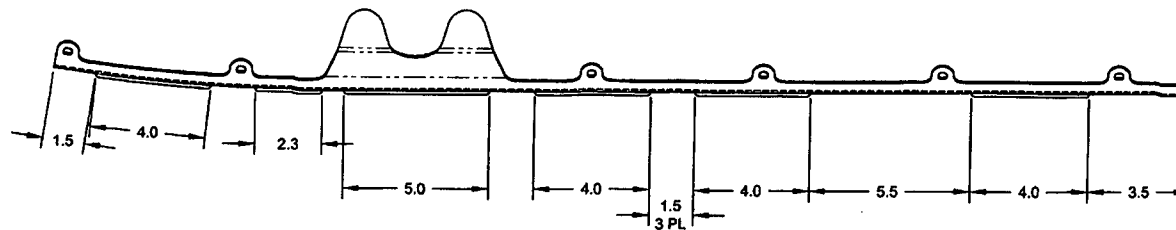
D4095-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240
OR ASME SA240 REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5
- 9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

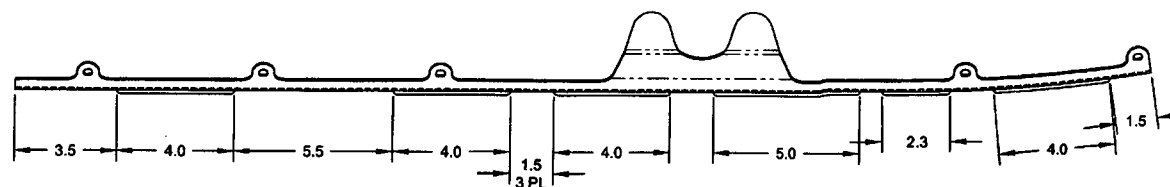
RELEASED
2016-01-11

DESIGN		DART AEROSPACE USA, INC
DRAWN		EUGENE, OR
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D4095 SHEET 5 OF 9
APPROVED		TITLE SCALE
DE APPR.		WEARPLATE NTS
DATE	16.01.06	

COPYRIGHT © 2010 BY DART AEROSPACE USA, INC
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



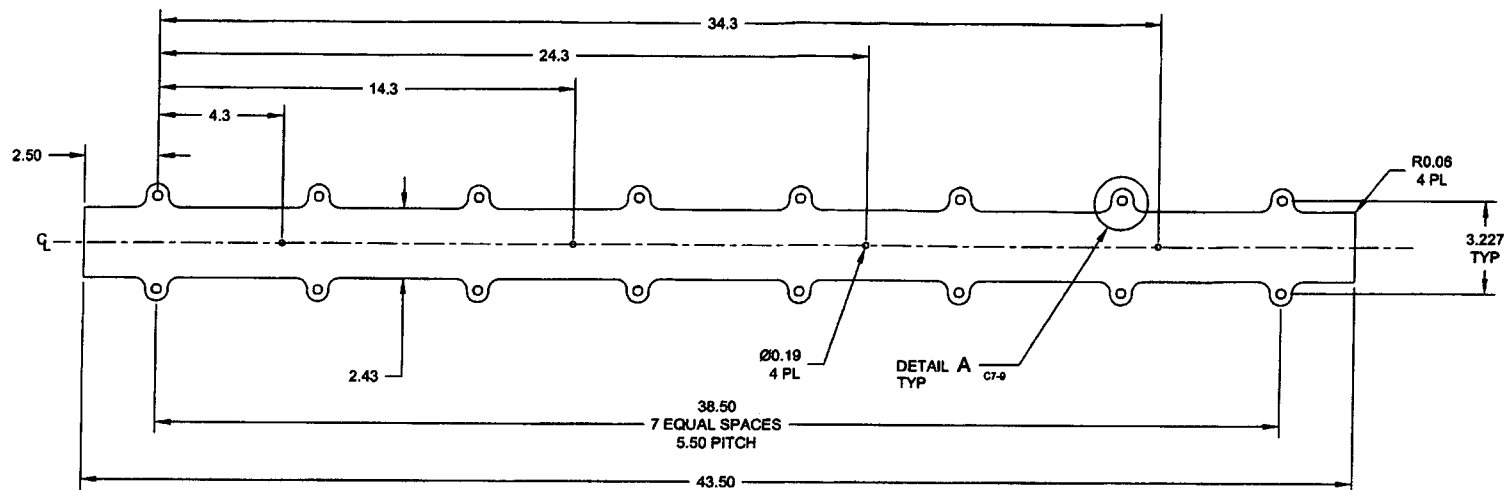
D4095-1 WELDING DETAIL



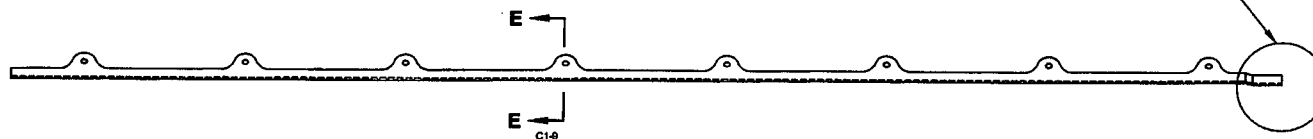
D4095-3 WELDING DETAIL

RELEASED
2016-01-11

DESIGN		DART AEROSPACE USA, INC	
DRAWN		EUGENE, OR	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>SS</i>	D4095	SHEET 6 OF 8
APPROVED	<i>DN</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	WEARPLATE	NTS
DATE	16.01.06	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D4095-5F FLAT PATTERN [1]



D4095-5 BENDING DETAIL
(MAKE FROM D4095-5F)

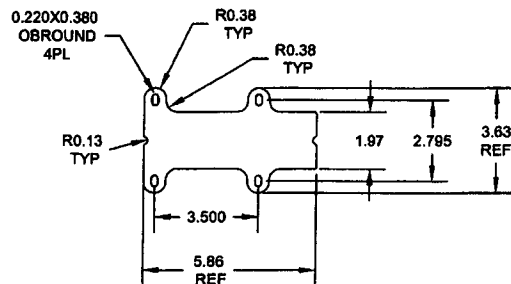
D4095-5 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240
OR ASME SA240 REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5
- 9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

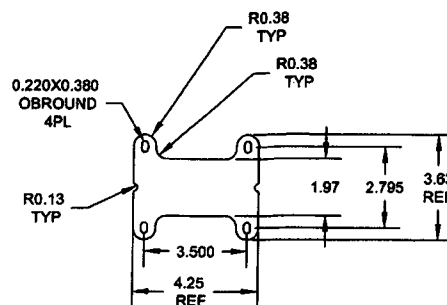
RELEASED
2016-01-11

DESIGN		DART AEROSPACE USA, INC
DRAWN		EUGENE, OR
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D4095 SHEET 7 OF 8
APPROVED		TITLE SCALE
DE APPR.		WEARPLATE NTS
DATE	16.01.06	

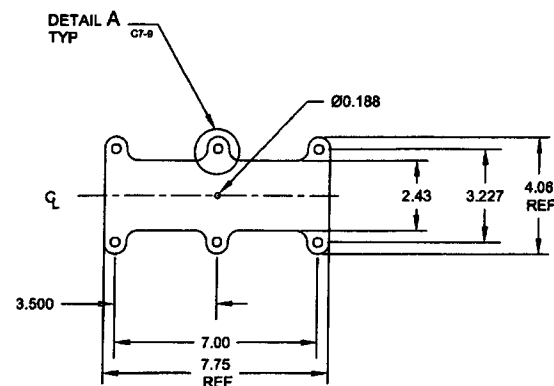
COPYRIGHT © 2010 BY DART AEROSPACE USA, INC
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC



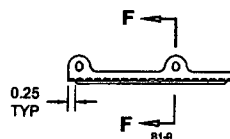
D4095-7F FLAT PATTERN 1



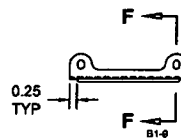
D4095-9F FLAT PATTERN 1



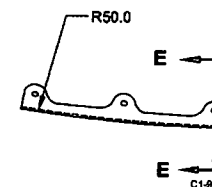
D4095-11F FLAT PATTERN 1



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

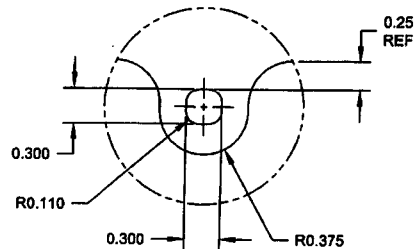
D4095-7/-9/-11 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240 REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5
- 9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

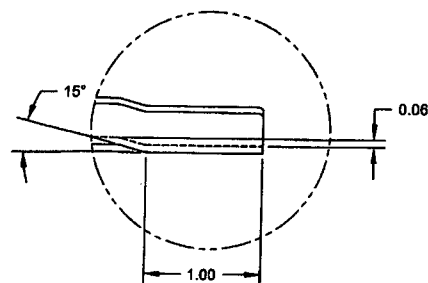


RELEASED
2016-01-11

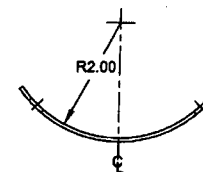
DESIGN		DART AEROSPACE USA, INC	
DRAWN		EUGENE, OR	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4095	SHEET 8 OF 9
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	16.01.06	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



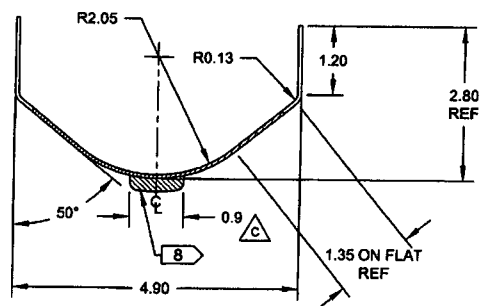
DETAIL A: TAB DETAIL
SCALE 4X
C3-3
C6-5
D3-7
D2-8



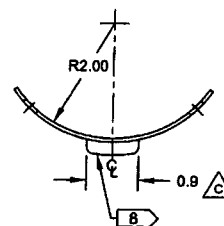
DETAIL B: JOGGLE DETAIL
SCALE 4X
B2-4
B6-4
B3-5
B2-7



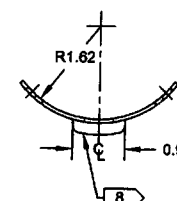
SECTION E-E
SCALE 2X
B5-7
B2-8



SECTION C-C
SCALE 2X
B5-4
B4-5



SECTION D-D
SCALE 2X
B4-4
B5-5



SECTION F-F
SCALE 2X
B5-8
B7-8

RELEASED
2016-01-11

DESIGN		DART AEROSPACE USA, INC
DRAWN		EUGENE, OR
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D4095 SHEET 9 OF 9
APPROVED		TITLE SCALE
DE APPR.		WEARPLATE NTS
DATE	16.01.06	

COPYRIGHT © 2010 BY DART AEROSPACE USA, INC
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

